

Work Order ID 86142

June-21-12 8:38:41 AM

86142

Page 1

Item ID: D4004-11

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Top Strap Attach Bracket

Stop ***NS2***

Start Date: 21/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLJDate: 12/06/21 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr**Revision Nbr**

D4004

A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

1-Cut D3033-144 extrusion to length per D4004-11 detail of dwg D4004

Ensure cut is started at correct place per dwg

Batch: _____

2-Deburr

12-06-28 4

105

0.00

105

Small Fab

Memo

0.00

Small Fab

Drill and c/sink holes as per dwg and trim part to length as required.

12-06-28 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86142

86142

Page 2

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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Top Strap Attach Bracket

Stop ***NS2***

Start Date: 21/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***


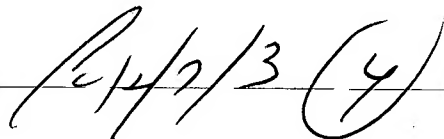
QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		872602125					
120 *120* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4		216 12-7-3	
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
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Page 3

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Start Date: 21/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: ST 14

0.00

140

Packaging

Memo

0.00

Packaging

44SP12-7-3

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/7/48UMF
12-07-3

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June-21-12 8:38:47 AM

Page 1

Work Order ID: 86142

86142

Parent Item: D4004-11

D4004-11

Parent Item Name: Top Strap Attach Bracket

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP rev A 09.12.15 new issue EC verified by:DD
10.05.17 as per ECN10-562 DD verf:EC
as per dwg rev.b DD verf: EC

IPP Rev:B
IPP Rev:C 12.03.07

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
40456-11-144		Purchased	No			100	f	0.0000	0.41	1.726316			

40456-11-144

**

SEAT TRACK

3033-144

B77193

1.8 ~~10~~ 12-06-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

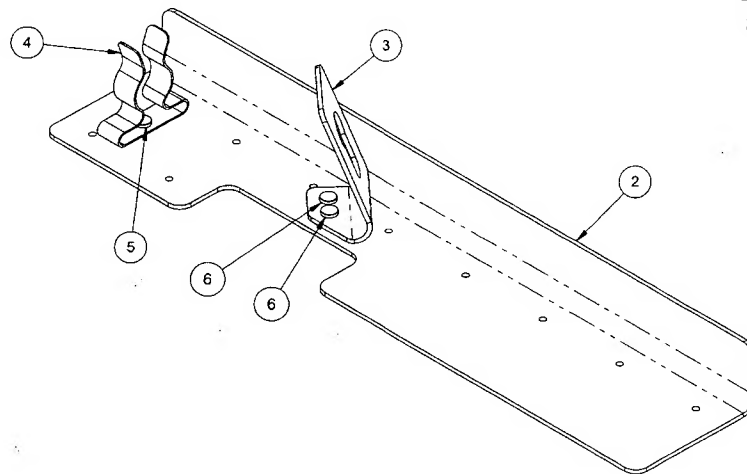
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NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4004-041	SIDE RESTRAINT ANGLE	JCA-M47-2-19
2	1	D4004-1	SIDE RESTRAINT	
3	1	D4004-3	ANGLE	
4	1	D4004-7	HOSE CLIP	
5	1	MS20426AD4-4	RIVET	
6	2	MS20426AD4-5	RIVET	



D4004-041 SIDE RESTRAINT ANGLE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 80142 MLO

12/06/21

RELEASED
2012-03-03
JD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.21 lbs



B	CHANGE POWDER COAT FROM "GREY SANDEXT" TO "ANSI 61 GREY", ZN A8-1, ZN A8-2.	DC	12.02.27
A	NEW ISSUE	HS	10.02.10
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>BC</i>		
CHECKED	<i>BC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>BC</i>	D4004	SHEET 1 OF 11
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	SIDE RESTRAINT	NTS
DATE	12.02.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

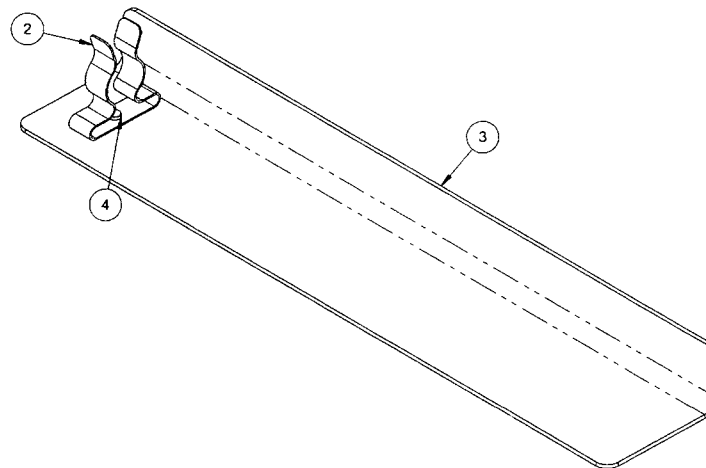
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4004-043	SIDE RESTRAINT ANGLE AND TIE DOWN POINT	JCA-M47-2-04
2	1	D4004-7	HOSE CLIP	
3	1	D4004-9	ANGLE	
4	1	MS20426AD4	RIVET	



D4004-043 SIDE RESTRAINT ANGLE AND TIE DOWN POINT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3 \triangle B
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.20 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>E</i>	D4004	SHEET 2 OF 11
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	SIDE RESTRAINT	NTS
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RELEASED
2012-03-22
NT

06142

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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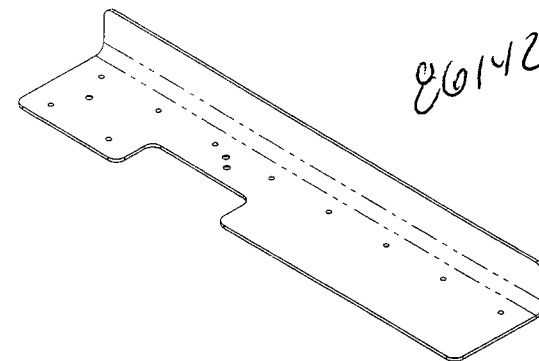
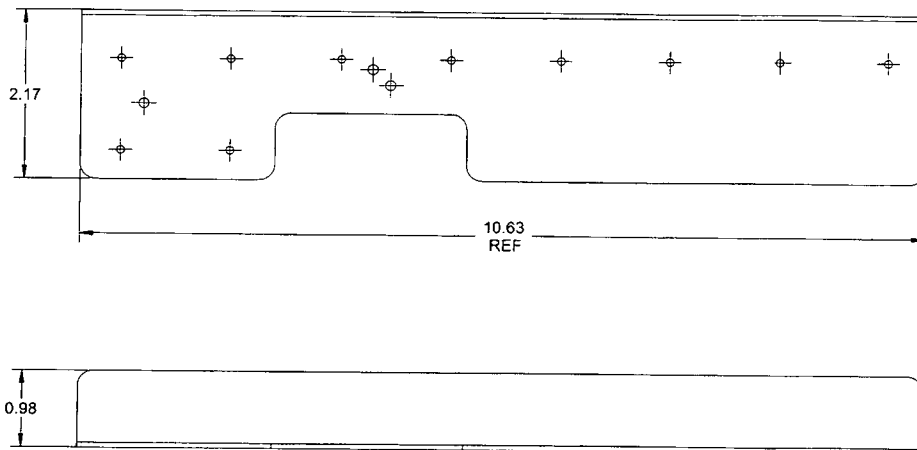
NOTE: Date & initial all entries

DART AEROSPACE
PART NUMBER

D4004-1

JOHN CAMERON AVIATION
PART NUMBER

REF JCA-M47-2-19



D4004-1 SIDE RESTRAINT

NOTES:

- 1) MATERIAL: MADE FROM D4004-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

RELEASED
2012-03-02
JMP

DESIGN	<i>BC</i>	DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO	REV. <i>B</i>
MFG. APPR.	<i>EE</i>	D4004	SHEET 3 OF 11
APPROVED	<i>142</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	SIDE RESTRAINT	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

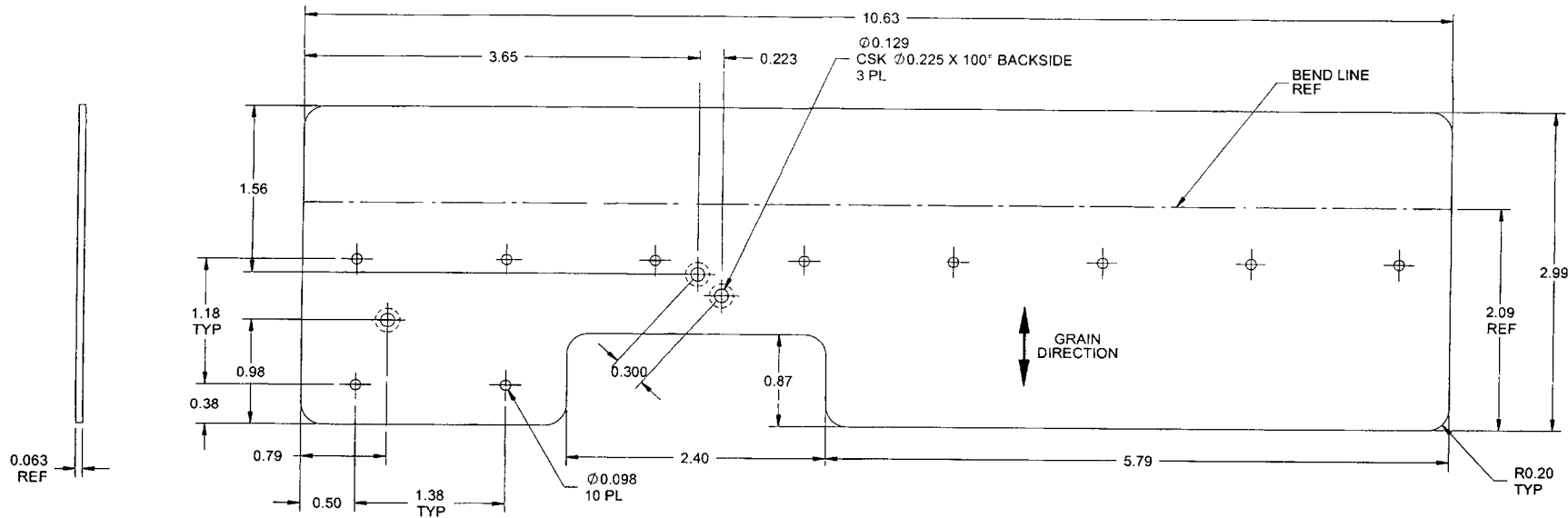
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80142



D4004-1F FLAT PATTERN

RELEASED
2012-03-02

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D4004	SHEET 4 OF 11
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	SIDE RESTRAINT	NTS
DATE	12.02.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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NOTE: Date & initial all entries

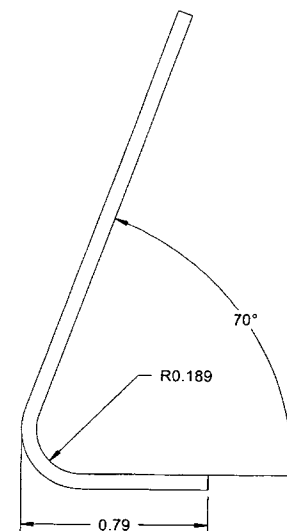
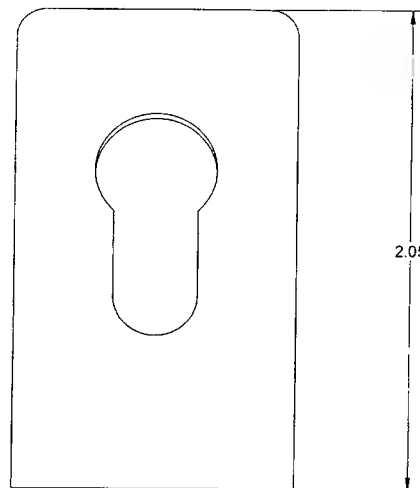
DART AEROSPACE
PART NUMBER

D4004-3

JOHN CAMERON AVIATION
PART NUMBER

REF JCA-M47-2-19

86142



D4004-3 STRUT LOCK BRACKET

RELEASED
2012-03-02
MP

NOTES:

- 1) MATERIAL: MADE FROM D4004-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D4004	SHEET 5 OF 11
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	SIDE RESTRAINT	NTS
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W/O:		WORK ORDER CHANGES					
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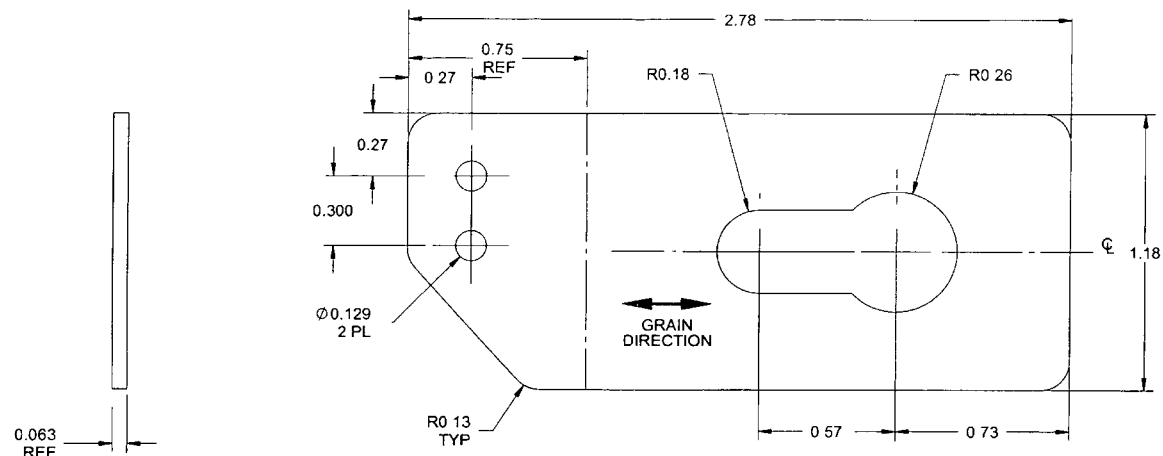
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

06142



D4004-3F FLAT PATTERN

RELEASED
2012-03-02

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.02 lbs

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D4004	SHEET 6 OF 11
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	SIDE RESTRAINT	NTS
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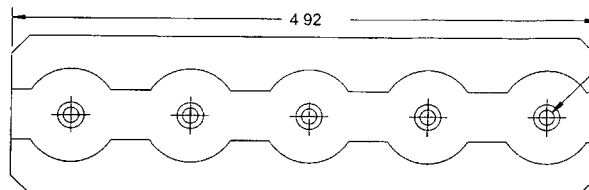
NOTE: Date & initial all entries

DART AEROSPACE
PART NUMBER

D4004-5

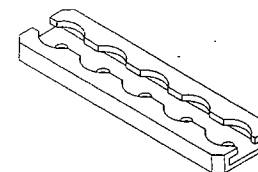
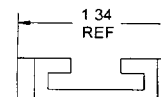
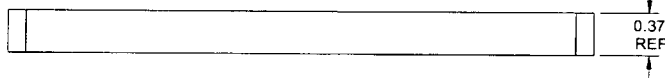
JOHN CAMERON AVIATION
PART NUMBER

JCA-M47-2-23



DRILL $\varnothing 0.129$ (#30 DRILL)
CONCENTRIC WITH SEAT TRACK
CSK $\varnothing 0.225 \times 100^\circ$
5 PL

CHAMFER 0.15 X 45°
TYP



26142

D4004-5 BOTTOM STRAP ATTACH BRACKET

RELEASED
2012-03-02

NOTES:

- 1) MATERIAL: MADE FROM ANCRA P/N 40456-11-144
OR BROWNLIN P/N 20276-144-0-0
OR D3033-144
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.14 lbs

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D4004	SHEET 7 OF 11
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	SIDE RESTRAINT	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

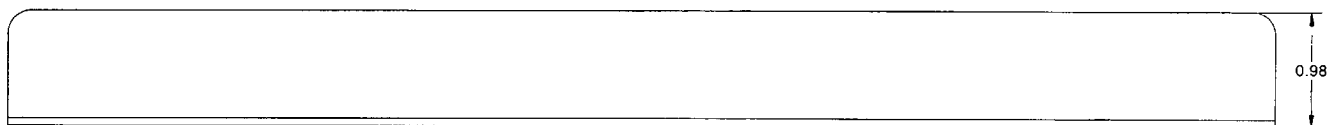
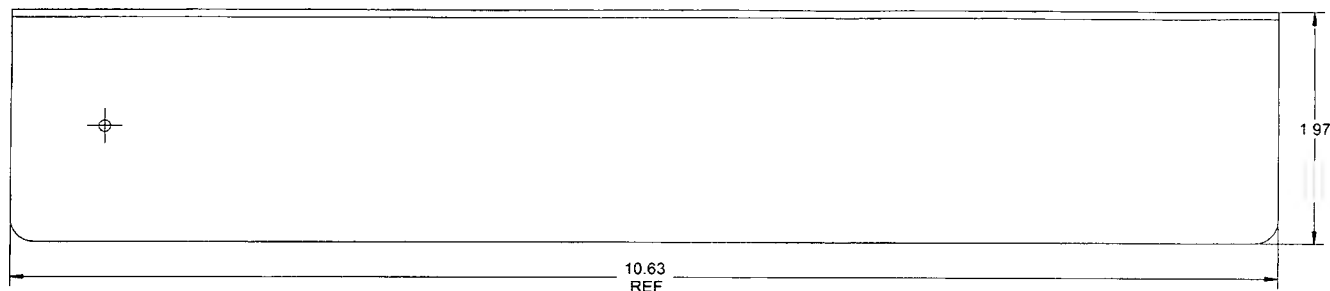
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-9	REF JCA-M47-2-04



D4004-9 ANGLE

- NOTES:**
- 1) MATERIAL: MADE FROM D4004-9F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.18 lbs

DESIGN	<i>BC</i>	DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>BC</i>	D4004	SHEET 9 OF 11
APPROVED	<i>BC</i>	TITLE	SCALE
DE APPR.	<i>BC</i>	SIDE RESTRAINT	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

20142

10.63

2.80

0.98

0.79

0.063 REF

GRAIN DIRECTION

CSK $\varnothing 0.179 \times 100^\circ$ BACKSIDE

$\varnothing 0.098$

BEND LINE

1.89 REF

R0.20 TYP

D4004-9F FLAT PATTERN

RELEASED
2012-03-00

NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.18 lbs

DESIGN	DE	DART AEROSPACE LTD	
DRAWN	DE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DE	DRAWING NO	REV. B
MFG. APPR.	DE	D4004	SHEET 10 OF 11
APPROVED	DE	TITLE	SCALE
DE APPR.	DE	SIDE RESTRAINT	NTS
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BACKSIDE

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BEND LINE

1.89 REF

R0.20 TYP

D4004-9F FLAT PATTERN

RELEASED
2012-03-01

NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
2) FINISH: N/A
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4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.18 lbs

DESIGN	DE	DART AEROSPACE LTD	
DRAWN	DE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DE	DRAWING NO	REV. B
MFG. APPR.	DE	D4004	SHEET 10 OF 11
APPROVED	DE	TITLE	SCALE
DE APPR.	DE	SIDE RESTRAINT	NTS
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R0.20 TYP

D4004-9F FLAT PATTERN

RELEASED
2012-03-01

NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
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REF DART SPEC M2024T3S.063
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3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.18 lbs

DESIGN	DE	DART AEROSPACE LTD	
DRAWN	DE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DE	DRAWING NO	REV. B
MFG. APPR.	DE	D4004	SHEET 10 OF 11
APPROVED	DE	TITLE	SCALE
DE APPR.	DE	SIDE RESTRAINT	NTS
DATE	12.02.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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0.063 REF

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CSK 0.179 X 100°
BACKSIDE

GRAIN DIRECTION

BEND LINE

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D4004-9F FLAT PATTERN

NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
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3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.18 lbs

DESIGN	DE	DART AEROSPACE LTD	
DRAWN	DE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DE	DRAWING NO	REV. B
MFG. APPR.	DE	D4004	SHEET 10 OF 11
APPROVED	DE	TITLE	SCALE
DE APPR.	DE	SIDE RESTRAINT	NTS
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- 20142

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CSK 0.179 X 100°
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R0.20 TYP

D4004-9F FLAT PATTERN

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1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
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REF DART SPEC M2024T3S.063
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.18 lbs

DESIGN	DE	DART AEROSPACE LTD	
DRAWN	DE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DE	DRAWING NO	REV. B
MFG. APPR.	DE	D4004	SHEET 10 OF 11
APPROVED	DE	TITLE	SCALE
DE APPR.	DE	SIDE RESTRAINT	NTS
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D4004-9F FLAT PATTERN

NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.18 lbs

RELEASED
2012-03-00

DESIGN	DE	DART AEROSPACE LTD	
DRAWN	DE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DE	DRAWING NO	REV. B
MFG. APPR.	DE	D4004	SHEET 10 OF 11
APPROVED	DE	TITLE	SCALE
DE APPR.	DE	SIDE RESTRAINT	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

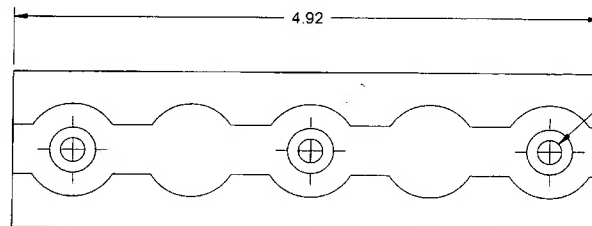
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

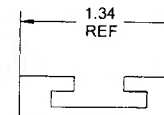
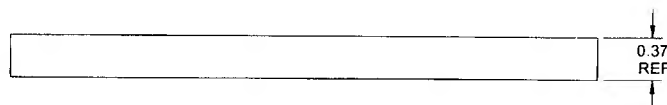
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-11	JCA-M47-2-11



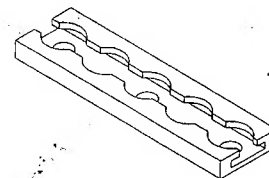
DRILL $\varnothing 0.204$ (#6 DRILL)
CONCENTRIC WITH SEAT TRACK
CSK $\varnothing 0.385 \times 100^\circ$
3 PL



D4004-11 TOP STRAP ATTACH BRACKET

- NOTES:
- 1) MATERIAL: MADE FROM ANCRA P/N 40456-11-144
OR BROWNLIN P/N 20276-144-0-0
OR D3033-144
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.14 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>BC</i>		
CHECKED	<i>JS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>JS</i>	D4004	SHEET 11 OF 11
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	SIDE RESTRAINT	NTS
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86142

2012-03-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

